

Date: Wednesday, 16/04/2008 3:53:38 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 38646
 Estimate Number : 10437
 P.O. Number :
 This Issue : 16/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL /MED FAB
 Previous Run : 38112
 Drawing Name : WEARPLATE
 Part Number : D33191
 Drawing Number : D3319 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 25/04/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC
 Est Rev:C Now on Waterjet 06-10-26 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048



Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s)
 1010/1025/A21/6aA SHEET .048
 Batch: 106348 B 8-4-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3319
 Dwg Rev: B B 8-4-18
 Prog Rev: B
 2-Deburr if necessary B 8-4-18



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

Handwritten notes: 08/04/18 (H12)

Handwritten notes: Done & sto 222
 06/04/18

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38646

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

- 1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B
- 2- Form flat on press using DT8776 block

JB 08/04/21

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/01/21 (+12)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- Layout weld location as per Dwg D3319 using jig D3319-1T3
- 2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

SP 08-04-29 (ex) (x1)
SP 08-04-25 (ex)
SP 08-04-

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	M106390

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/01/29 (x6)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/29 (x6)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

08-04-29

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

m-f

08/04/29 (6x)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX
For Product Eligibility see PDA05-18

08/04/29 (6)

1338646
D 33191
29/04/2008
S.150
#1 13.36
#2 315.7
#3 M1105
#4

Process Sheet

Customer: CU-DAR001 Part Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38646

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

and Stock

Location: _____

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/30 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

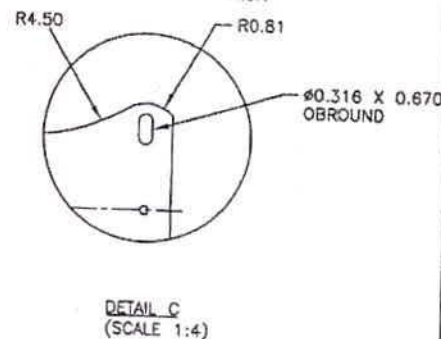
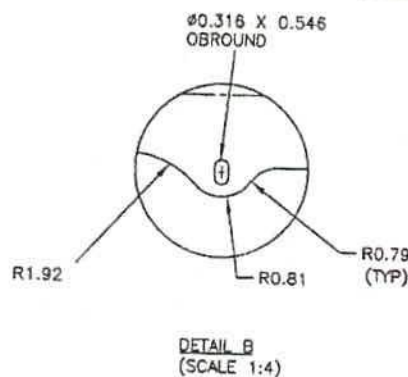
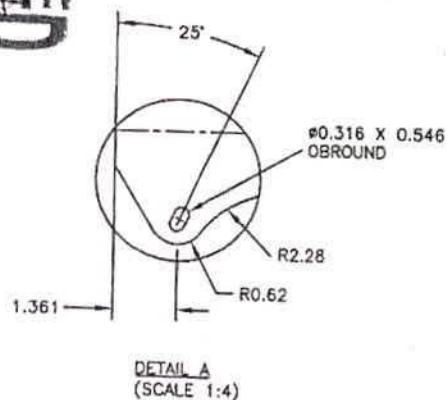
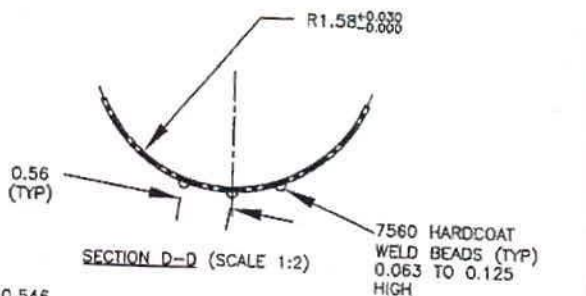
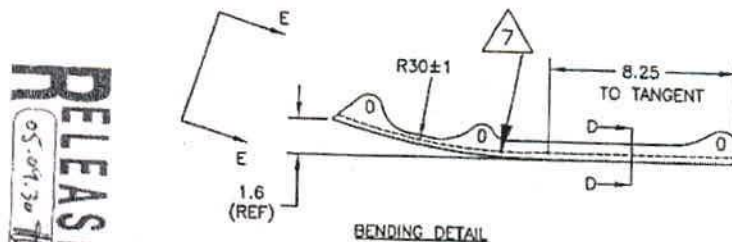
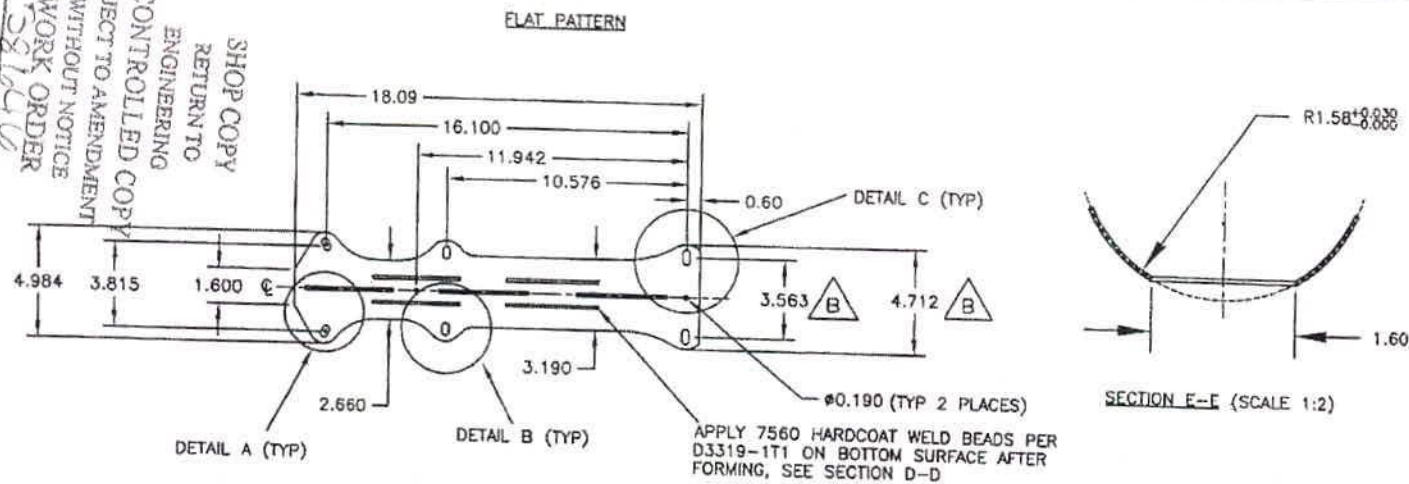
Job Completion



u. 08-04-30

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	04	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	05.06.06	D3319
05.06.06	04.09.24	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
	05.06.06	WEARPLATE
		NEW ISSUE
		SCALE
		1:8



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05-01-30

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